

# Work Order ID 94291

**\*94291\***

Page 1

December-05-12 12:48:19 PM

Item ID: D205-708-011

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Adjustable Engine Mount

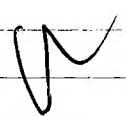
Start Date: 12/05/12 Start Qty: 2.00 **\*2\***

Cust Item ID:

Required Date: 12/06/12 Req'd Qty: 2.00 **\*2\***

Customer:

Reference:

Approvals: Process Plan:  Date: Tooling: Date:

Run Start **\*NR1\***

QC: Date: SPC (Y/N): Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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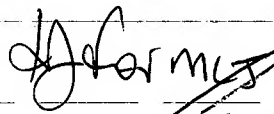
Draw Nbr	Revision Nbr
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B80701	Rev C
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100		0.00							
<b>*100*</b>	DOCUMENT CONTROL								
DC	Memo	0.00							
Document Control	Photocopy bluefile and create labels per PPP D205-708-011, CHG001								


DAS  
15  
9-89

12/12/11

2  12-12-11 (2)

135	Pick Kit	0.00							
-----	----------	------	--	--	--	--	--	--	--

<b>*135*</b>									
Packaging	Memo	0.00							
Packaging									

 12/12/11 (2)

140	QC4- 100% Inspect kits for completeness	0.00							
-----	---	------	--	--	--	--	--	--	--

<b>*140*</b>									
QC	Memo	0.00							
Quality Control									

DAS  
15  
9-89

12/12/11

2

**Work Order ID 94291****\*94291\***

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Item ID: D205-708-011

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Adjustable Engine Mount

Start Date: 12/05/12 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 12/06/12 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

0.00

**\*150\***

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D205-708-011

Location: **16 G24**

PPP Rev: \_\_\_\_\_

(2) 12/12/12 **DAS**  
20  
3-69

160

QC21- Final Inspection - Work Order Release

0.00

**\*160\***

QC

Memo

0.00

Quality Control

12/12/13 **dg**

12-12-12

# Picklist Print

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Work Order ID: 94291

Parent Item: D205-708-011

Parent Item Name: Adjustable Engine Mount

Start Date: 12/05/12

Required Date: 12/06/12

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP C 06.01.31 Added MS206136C12 JLM/AP  
IPP Rev:D 07-12-12 as per ECN 1074 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3284-001 Sleeve	B 80702-1	Manufactured	No			140	Each	6.0000	6	12			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST037		6							
				24757		6							
D3284-003 Stud	B 80703-1	Manufactured	No			140	Each	5.0000	2	4			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST037		5							
				32724		3							
				35656		2							
D3284-005 Stud	B 80704-1	Manufactured	No			140	Each	11.0000	4	8			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST037		11							
				24757		6							
				43645		3							
				79831		2							
D3284-007 Stud	B 80705-1	Manufactured	No			140	Each	6.0000	6	12			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST037		6							
				24757		6							
D3284-009 Bearing		Manufactured	No			140	Each	18.0000	6	12			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST037		18							
				91712		18							

SHB 27

37468 GP

24757 GP

32724 GP

35656 GP

24757

55437 GP

24757 GP

24775 12/14/10

2

# Picklist Print

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Work Order ID: 94291

Parent Item: D205-708-011

Parent Item Name: Adjustable Engine Mount

Start Date: 12/05/12

Required Date: 12/06/12

Start Qty: 2.00

Required Qty: 2.00

~~D3284-011~~  
Bearing

Manufactured No

140 Each 3.0000

1 2 24776

Location Loc Qty Loc Code

ST037 3  
60004 3

~~MS20613-6C12~~  
RIVET

Purchased No

140 Each 68.0000

2 4 1000F9

Location Loc Qty Loc Code

ST312 68  
105433 68

~~MS20613-6C16~~  
Rivet

Purchased No

140 Each 436.0000

8 16 m19392 12x

Location Loc Qty Loc Code

ST312 436  
115358 436

m115353 4x

~~MS20613-6C18~~  
Rivet

Purchased No

140 Each 7.0000

4 78

Location Loc Qty Loc Code

ST312 7  
19513 7 11

19513

~~MS20613-6C19~~  
Rivet

Purchased No

140 Each 0.0000

12 24 76250

~~NASS09-12~~  
Nut

Purchased No

140 Each 48.0000

6 12 12/12/80

Location Loc Qty Loc Code

ST279 48  
15057 42  
24757 6

24757

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Shop Packet Print

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Work Order ID: 94291

Parent Item: D205-708-011

Start Date: 12/05/12

Required Date: 12/06/12

Parent Item Name: Adjustable Engine Mount

Start Qty: 2.00

Required Qty: 2.00

~~NASS69L12~~

Purchased

No

140

Each

44.0000

6

12

Nut

## Location

## Loc Qty

## Loc Code

ST279

44

102296

29

15062

9

24757

6

24757

*[Signature]*  
12/12/12  
(2)

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ICA-D205-708

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## 71.4 PARTS LIST

Qty -043	Qty -013	Qty -041	Qty -011	Part Number	Description
			X	D205-708-011	ADJUSTABLE ENGINE MOUNT KIT (205/UH-1)
		X		D205-708-041	ADJUSTABLE ENGINE MOUNT ASSEMBLY (205/UH-1)
	X			D204-708-013	ADJUSTABLE ENGINE MOUNT KIT (204)
X				D204-708-043	ADJUSTABLE ENGINE MOUNT ASSEMBLY (204)
	6		6	D3284-001	SLEEVE
			2	D3284-003	STUD
	6		4	D3284-005	STUD
	6		6	D3284-007	STUD
	6		6	D3284-009	BEARING
	1		1	D3284-011	BEARING
1				D3284-021	TUBE ASSEMBLY
1				D3284-023	BIPOD ASSEMBLY
1				D3284-025	TRIPOD ASSEMBLY
		1		D3284-031	TUBE ASSEMBLY
		1		D3284-033	BIPOD ASSEMBLY
		1		D3284-035	TRIPOD ASSEMBLY
	2		2	MS20613-6C12	RIVET
	12		8	MS20613-6C16	RIVET
			4	MS20613-6C18	RIVET
	12		12	MS20613-6C19	RIVET
	6		6	NAS509-12	NUT
	6		6	NAS509L-12	NUT

## 71.5 WEIGHT AND BALANCE

The following is the net weight and moment change associated with this installation

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D205-708-011 Adjustable Engine Mount Kit (205/UH-1)	9.6 lb 4.4 kg	-3.0 in -0.08 m	-28.8 lb-in -0.35 kg-m	188.5 in 4.79 m	1810 lb-in 21.1 kg-m
D205-708-041 Adjustable Engine Mount Assembly (205/UH-1)					
D204-708-013 Adjustable Engine Mount Kit (204)	9.6 lb 4.4 kg	-3.0 in -0.08 m	-28.8 lb-in -0.35 kg-m	184.5 in 4.69 m	1771 lb-in 20.6 kg-m
D204-708-043 Adjustable Engine Mount Assembly (204)					

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71-00-00

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